Work Ord	er ID	10889
October-29-13		AM
I. ID	D2202	

D 3 2 0 2 - 1 B 1 0 8 8 9 2

\*108892\*



Revision ID:	D3202-1 Cover		Accept	*N900	<u>040</u>	100	<b>)*</b> s	etup Star Stop	ı V	S1* S2*	
•	10/29/13 Start Qty: 10.00 10/29/13 Req'd Qty: 10.00	*10* *10*		Cust Item l Customer:	D:				10.		
Approvals:	Process Plan: MLD	- ·			ate:		R	tun Star Stoj	1/1	R1* R2*	
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										
D3202	Rev D										
100 *100* Waterjet FLOW CNC Waterjo らならる・ひろ			0.00				10	C_		Ac 13.12.	VI.
110 *1 1 <b>1</b> * QC Quality Control	QC2- Inspect parts off n . Memo	nachine FAI/FAIB	0.00				_10	<b></b>		<u>de</u> 13·12	11

DQA:	•	,Date:										AA PT
	٠				WORK ORDER NON-	-C(	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:		Date:		*			,	·	W	ork Order up	date only	
Work Orde	er:				DISPOSITION			AGAII	NST DE	PARTMENT	/PROCESS	
				<del></del>	Rework	1		Skid-tube Crosstu	ube	]	Water Jet	Engineering
Part N	lo.				Scrap			Machining Small	_	Pro	d. Eng. Coor.	Quality
					Use-as-is		Therr	noforming Finish	ing	-1	e/Packaging	Other
NCR N	lo.				Suspected Unapproved			Large Fab Compos	site		Supplier	
							<u> </u>			_		
Root				Desc	ription of work order update	l	Initial	Action		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Design												
Doc/Data			į									
Equip/Tooling						1						
Handling/Pre												
Material			l									
Operator	_											
Offset/Setup			1			l						
Process	-		1			1						
Supplier 					-							
Training	_											
Transport												
Unapproved			<u> </u>	<u>.                                    </u>		<u> </u>	III T CAT	FECORY				
Landii	ng Gear				General	FA	ULI CA	TEGORY				
Canan	Bendin	σ.			Bend		ا دمانه ۱	Program		]o		¬
		ಕ Not Conce	ntric	-	BOM/Route	$\vdash$	Grain	Togram	-	Outside Dim		Pressure/Forced
	Cracks	Not conce	intric		Broken/Damage/Defect	┢	Hardwa	aro.		Over/Under Part Incorred	<del></del>	Set-up
	—	Kink/Ripple	e/\Mave	-	Burrs	⊢	1	ion Incomplete/Unqualified	<u> </u>	Part Lost/Mi		Temperature/Cure
	Cuffs	miny mppi	c, wave		Contamination	$\vdash$	1 .	tions Incomplete/Unclear		-		Weld
	Crushi	าต			Countersink	$\vdash$	1	gned/off center	-	Part Moved Positioned V	L_	Wrong Stock Pulled
	Heat T	_		<b>+</b>	Cut Too Short	$\vdash$	Mislabe		$\vdash$	Power Loss/		Other
		tion Strip ir	ı Tube		Drawing	-	Misread		<u> </u>	Ti omei rossi.	ourge	Other
		Chatter		-	Drill Holes	-	Off-set					-
		g Sequence	9		Finish	$\vdash$		Calibration				
		Twist in Tu			Fit/Function	$\vdash$	4	Seguence				

Page 2

Insp.

October-29-13 10:13:10 AM

\*N900040100\* Item ID: D3202-1 Accept Setup Start Revision ID: Item Name: Cover \*10\* 10/29/13 **Start Oty: 10.00** Start Date: **Cust Item ID:** Required Date: 10/29/13 Reg'd Oty: 10.00 **Customer:** Reference: Run Process Plan: \_\_\_\_ Date: \_\_\_ Tooling: Date: \_\_\_\_\_\_\_ Approvals: Stop QC: \_\_\_\_\_ Date: \_\_\_\_ SPC (Y/N): Date: \_\_\_\_\_ Reject Tool ID Tool # Plan Accept Reject Sequence ID/ Operation Set Up/ Number Stamp Work Center ID Code **Qty** Oty **Description Run Hours** QC8- Inspect parts - second check 0.00 120 DAS \*120\* 27 0.00 OC Memo Quality Control Chemical Conversion Coat per QSI005 4.1 0.00 130 NG 1312-11

\*120\* HandFinish

Hand Finishing

Memo

0.00

140.;

\*140\*

Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

m 125028.

FINISH TIME: 6.00

0.00

0.00

10 \$ B-12-11

DQA:		Date:						_						277
QA Closed:		Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UI	PDATE	W	ork Order up	ndate only	AEROSI	PACE
					DISPOSITION				AGAINST		PARTMENT			
Work Orde	r:					,		—			1	_	$\neg$	
D N				1	Rework			Skid-tube	Crosstube	-	_	Water Jet	Engineering	_ 1
Part N	10.			-	Scrap			Machining	Small Fab	-	1	d. Eng. Coor.	Quality	_
NCR N	lo.				Use-as-is Suspected Unapproved		Inerr	noforming Large Fab	Finishing Composite	_	Rec/Stor	re/Packaging Supplier	Other	$H \mid$
				_		J				L	1			
Root				Descr	iption of work order update		Initial	Act	ion		Sign &			
Cause	Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	iption		Date	Verification	QC Inspec	tor
Design														
Doc/Data														
Equip/Tooling	_													
Handling/Pre	_													
Material														
Operator														
Offset/Setup														
Process	_						٠							
Supplier	_													
Training	_													
Transport	_													
Unapproved		<u> </u>						<u>L_</u>						
						FAI	ULT CAT	TEGORY						
Landin	g Gear				General	_	1			_	7	_	_	
-	Bending			<b>⊢</b> —	Bend	_	1	rogram		_	Outside Dim		Pressure/Force	:d
-	Centre No	ot Concer	ntric	_	BOM/Route		Grain			_	Over/Under	<b>;</b> —	Set-up	
-	Cracks				Broken/Damage/Defect	$ldsymbol{ldsymbol{eta}}$	Hardwa			L	Part Incorred	<b>⊢</b>	Temperature/C	Cure
-	Crimp/Kir	ik/Rippie	/Wave	-	Burrs	<u> </u>	1	on Incomplete/Un	•	_	Part Lost/Mi	· -	Weld	
,	Cuffs			<b>—</b>	Contamination		1	ions Incomplete/U	Inclear	_	Part Moved		Wrong Stock Pu	ulled
}	Crushing			-	Countersink	-	1	ned/off center			Positioned V		_	
-	Heat Trea		<b>-</b> .	$\vdash$	Cut Too Short	-	Mislabe				Power Loss/	Surge	Other	
}	Inspectio	٠.	ıube	-	Drawing	_	Misread	i						
}	Marks/Ch			-	Drill Holes	-	Off-set							
}	Turning S	-		-	Finish	<u> </u>	1	Calibration						
	Wave/Tw	ust in Tub	16	1 1	Fit/Function	1	I Out of 9	Coguenco						

Page 3

October-29-13 10:13:10 AM

Item ID:

D3202-1

Accept

\*N900040100\*

Setup Start

**Revision ID:** 

Start Date:

Cover Item Name:

Required Date: 10/29/13

10/29/13

**Start Oty: 10.00** Req'd Qty: 10.00

\*10\* \*10\*

**Cust Item ID:** 

**Customer:** 

**Tool ID** 

Reference:

Approvals:

Process Plan: Date: Tooling:

Date:

SPC (Y/N):

Set Up/

Date: Date:

Run

Stop

Sequence ID/ Work Center ID 150

\*150\*

QC Quality Control Operation Description

QC:\_\_\_\_

QC3- Inspect Part Finish

Memo

**Run Hours** DAS 0.00

27

Tool # Plan Accept **Qty** Code

Reject Qty

Reject Number

Insp. Stamp

\*160\*

Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

10

DAS

170

\*170\* QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

Memo

0.00

0.00

M/ Pl 13-12-16

DQA:		Date:			WORK ORDER NON	~	21150	DA 4 4 4 6 5 1 1 11					DART
QA Closed:		Date:			WORK ORDER NON	-((	JNFO	RIVIANCE / U	PDATE	Wo	rk Order up	odate only	AEROSPACE
Morle Orde					DISPOSITION				AGAINST		ARTMENT		
Work Orde	er			_	Davis di	1		s:: [ ]		_			
Part N	lo				Rework Scrap			Skid-tube Machining	Crosstube Small Fab	—-	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	No				Use-as-is Suspected Unapproved		Therr	noforming Large Fab	Finishing Composite	—	Rec/Stor	e/Packaging Supplier	Other
Root				Desci	ription of work order update		nitial	Act	ion		Sign &		
Cause	Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	1	Date	Verification	QC Inspector
Design													,
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator						-2							
Offset/Setup													
Process						}							
Supplier					•								
Training													
Transport													
Unapproved													
						FAL	JLT CA	EGORY					
Landir	ng Gear				General								
	Bending				Bend		Folio/P	rogram		$\Box$	Outside Dim	ensions	Pressure/Forced
	Centre N	ot Concer	ntric		BOM/Route		Grain				Over/Under	tolerance	Set-up
	Cracks				Broken/Damage/Defect		Hardwa	re			Part Incorrec	:t	Temperature/Cure
	Crimp/Kii	nk/Ripple	/Wave		Burrs		Inspect	on Incomplete/Un	qualified		Part Lost/Mis	ssing	Weld
	Cuffs				Contamination		Instruct	ions Incomplete/L	Inclear		Part Moved		Wrong Stock Pulled
	Crushing				Countersink		Misalig	ned/off center			Positioned W		_ ~
	Heat Trea	at			Cut Too Short		Mislabe			-	Power Loss/S		Other
	Inspectio	n Strip in	Tube		Drawing	П	Misread	f	· ·		·	·	
[	Marks/Ch	natter			Drill Holes	П	Off-set			-			
	Turning S	equence			Finish	П	Out of (	Calibration		-			
ļ	Wave/Tw	ist in Tub	e e		Fit/Function	П	Out of 9	Seguence		-			

Page 1

Work Order ID:

108892

Parent Item:

Comments:

D3202-1

Parent Item Name:

Cover

100072

IPP Rev:B No Longuer Made In House IPP Rev:C Now on Waterjet

IPP Rev:D

chg to revC as per dwg

05-11-06 JLM 07-04-18 JLM

08-04-21 DD verified by:JLM

**Start Date:** 10/29/13

Required Date: 10/29/13

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/	Replacement	Mag-/			Last	•	Unit of	Qty on	Qty per Kit	Total		Date	Status
Item Name	Item ID	Mfg/ Purch	Bin Item	Primary Location	Location	Route Seq ID	Measure		Qty per Kit	Total Qty	Qty Issued	Issued	Status
M5052H32S.032 5052-H32 .032 Sheet		Purchased	No	<u> </u>	· • · · · · · · · · · · · · · · · · · ·	100	sf	450.7570	1.551	16.326316	A	13	12.11
• • • • • • • • • • • • • • • • • • •				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT020		87.6							
				121	660	87.6							,
				MAT022		363.157							
				112	664	10.4		•					
				115	638	12							
				116	657	9.5							
				117	798	34.8							
				121	030	46							
				121	040	23							
				125	552	16				: •			
				m12	26593	211.457			13	16593 -	$\rightarrow$	16.3	3

DQA:			Date:						_					<b>A</b>	
QA Closed:			Date:			WORK ORDER NON	-C(	ONFO	RMANCE / UI		Wor	k Order up	date only	ر <u>ن</u> ^	EROSPACE
		:				DISPOSITION				AGAINST I	,	· ·		<u>. 1</u>	
Work Orde	er: _				_		,			_	_	•	<b>,</b> —	_	
Part N	۱٥	:			_	Rework Scrap			Skid-tube Machining	Crosstube Small Fab			Water Jet d. Eng. Coor.	<b>-</b> ;	eering Quality
NCR N	No					Use-as-is Suspected Unapproved		Thern	noforming Large Fab	Finishing Composite		Rec/Stor	e/Packaging Supplier		Other
Root					Desci	ription of work order update		nitial	Act	ion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	QC	Inspector
Design Doc/Data				·	,										
Equip/Tooling															
Handling/Pre															
Material														1 .	,
Operator															
Offset/Setup															
Process														ŀ	
Supplier															
Training															
Transport									1						
Unapproved									4			!			
		-					FAI	ULT CA	TEGORY						
Landi	ng Ge	ar				General									
:	В	ending				Bend		Folio/F	Program	ſ		Dutside Dim	ensions	Pressure	e/Forced
	c	entre No	t Concer	ntric		BOM/Route		Grain			$\Box$	Over/Under	tolerance	Set-up	
	c	racks	•			Broken/Damage/Defect		Hardwa	ire		F	art Incorrec	t 🗆	Temper	ature/Cure
	c	rimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	F	art Lost/Mis	ssing	Weld	
	c	uffs				Contamination		Instruct	ions Incomplete/U	Jnclear	F	art Moved	. [	Wrong S	Stock Pulled
		rushing				Countersink		Misalig	ned/off center	Ī	F	ositioned W			·
	Щн	eat Trea	t			Cut Too Short		Mislabe	eled		F	ower Loss/S	Surge	Other	
	∐lr	rspection	Strip in	Tube		Drawing		Misread	d	•					
	∟∐۸	1arks/Ch	atter			Drill Holes		Off-set			_				
	Шт	urning Se	equence			Finish		Out of 0	Calibration		_				
	Ιlν	Vave/Tw	ist in Tuh	10		Fit/Function		Out of	Coguenco		_				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

DART AEROSPACE LTD	Work Order:	108892
Description: Cover	Part Number:	D3202-1
Inspection Dwg: D3202 Rev: D		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.38	+0.006/-0.001	.38_	-		V	JKm-05
0.63	+/-0.030	.63	•-		<b>V</b>	
3.38	+/-0.030	3.38			V	
2.40	+/-0.030	241		·	V	
0.82	+/-0.030	,82	_		<b>V</b>	
73.84	+/-0.030	73.84	م		T _	JKm-cb
74.50	+/-0.030	14,50			T	
0.032	+/-0.010	1033	<b>ح</b> بر		V	
4.03 Pitch	+/-0.030	•				
			DAS			

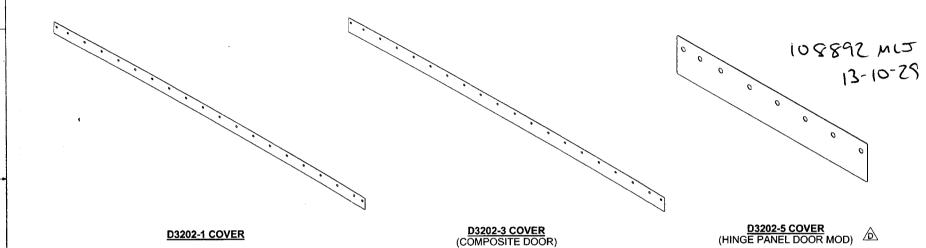
Measured by: Ac Audited by: 9-89 Preliminary Approval:

Date: 13.13.11

Date: 13.13.11

Date: 13.13.11

Rev	Date	Change	Revised by	Approved
Α	04.02.25	New Issue	KJ/RF	
В	06.09.28	Revised per Rev. B1	KJ/JLM	
С	08.07.23	Dimensions updated per Dwg Rev C	KJ/DD 🕜	
D	12.05.14	Dwg Rev updated	KJ 😽	CLIII
			71	



ADD -5 FOR HINGE PANEL DOOR MOD. AJS 08.11.03 ADD -3 FOR COMPOSITE DOOR. REFORMAT ENTIRE DRAWING TO SOLIDWORKS STANDARD. INCORPORATE CHANGE B1 (CLARIFY MID-SPAN DIMENSION) 08.03.31 AJS

DESCRIPTION BY DATE REV. DESIGN <sub>I</sub>DS **DART AEROSPACE LTD** AJS DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. D D3202 MFG. APPR. SHEET 1 OF 3 TITLE SCALE **COVER** NTS

APPROVED DE APPR. COPYRIGHT © 2008 BY DART AEROSPACE LTD

-45 DOCUMENT BY PRIVATE AND COMPOSITING AND BIS BURNESS ON THE CUPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PARROSE OF COMPUS OF COAMULA REPORT TO MAY TO HER PRIVATE OF COMP DATE 08.11.03

NOTES:
1) MATERIAL: 5052-H32 ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF. DART SPEC M5052H32S.032
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3202-X" USING FINE POINT PERMANENT INK MARKER 7) WEIGHT: 0.56 Ibs APPROX FOR -1 0.61 lbs APPROX FOR -3

0.18 lbs APPROX FOR -5

8

4

RE-DESIGN PART NOW CURVED

NEW ISSUE

В

Α

3

CP

CP

03.10.16

01.01.01

